

Classifications

EN ISO 14174

S A AB 1 67 AC H5

Characteristics and typical fields of application

UV 400 is an agglomerated flux of aluminate basic type designed for joining and surfacing applications with general-purpose structural steels, fine grained structural steels, boiler and pipe steels. The flux is characterized by its low silicon and moderate manganese pickup. It can be used on DC and AC. Its good welding characteristics and the technological properties of the weld metal produced with different wires permit universal use.

Flux properties

Polarity	DC / AC
Basicity index (Boniszewski)	2.3 Mol % 1.7 wt-%
Grain size (EN ISO 14174)	3 – 20 (0.3 – 2.0 mm)
Flux consumption	1.5 lbs flux per lb wire
Redrying	600°F +/- 25 for 2 hrs min.
Diffusible hydrogen (ISO 3690)	≤ 5 ml / 100 gr deposited weld metal (as produced / re-dried)

Composition of sub-arc welding flux

	SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
wt. %	20	30	26	16